



FW 316L Si

CODIFICATION: AWS : SFA 5.9 ER316LSi

CHARACTERISTICS AND APPLICATIONS:

FW 316L Si is a solid wire for TIG welding, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality weld deposit. This filler metal reduces the possibility of intergranular chromium carbide precipitation and thereby increases the resistance to intergranular corrosion. Silicon improves the usability of the filler metal in the GTAW process. It is suitable for welding similar grade of stainless steels.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Cr	Ni	Mo
Percent	0.022	1.58	0.85	0.015	0.020	19.20	12.50	2.45

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	Elongation
(MPa)	(L = 4d) %
570	35.0

SHIELDING GAS: Argon

CURRENT CONDITIONS: DCEN

WELDING POSITIONS: H, F, VU, OH

PACKING:

STANDARD SIZE: Diameter 1.6 mm, 2.0 mm, 2.4 mm & 3.2 mm in cut lengths of 1000 mm each.

QUANTITY 5 kgs wire put in an air-tight polythene bag and finally packed in a plastic container.
Identification – AWS code is punched on each wire.